

Work Order ID 130257

Monday, March 02, 2015 10:45:47 AM

130257

Page 1

Item ID: D350-607-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Automatic Lid Opener (Long Basket, Non Split Lid)

Start Date: 3/02/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/05/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 15-3-2

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

SP

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-607-141
CHG001DAS
06
9-89

MLJ 15-04-15

APR 15 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
26
9-89 APR 15 2015

IX

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
06
9-89

APR 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID 130257

Monday, March 02, 2015 10:45:47 AM

130257

Page 2

Item ID: D350-607-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Lid Opener (Long Basket, Non Split Lid)

Start Date: 3/02/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/05/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-141

Location: Q23

PPP rev: _____

DAS

06

0-89

APR 15 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 15-04-15MLJ 15-04-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 130257

130257

Parent Item: D350-607-141

D350-607-141

Parent Item Name: Automatic Lid Opener (Long Basket, Non Split Lid)

Start Date: 3/02/15

Required Date: 3/05/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC

IPP RevB: as
IPP Rev:C as per ecn10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3953-1		Manufactured	No			110	Each	34.0000	2	2			
D3953-1									**				DAS 26 9-89
Gas Spring Bracket													

DAS
06
9-89

Location	Loc Qty	Loc Code
ST069	20	
109116	20	
ST077A	14	
94730	14	

DAS
28
9-89

D3953-3		Manufactured	No			110	Each	51.0000	2	2			
D3953-3									**				DAS 26 9-89
Gas Spring Stud, Lid													

DAS
06
9-89

Location	Loc Qty	Loc Code
ST077A	51	
115828	20	
122668	10	
124029	21	

DAS
28
9-89

D3953-5		Manufactured	No			110	Each	26.0000	2	2			
D3953-5									**				DAS 26 9-89
Gas Spring Stud, Base													

DAS
06
9-89

Location	Loc Qty	Loc Code
ST069	5	
111522	5	
ST077A	21	
124030	21	

DAS
28
9-89

APR 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Monday, March 02, 2015 10:45:52 AM

Page 2

Work Order ID: 130257

130257

Parent Item: D350-607-141

D350-607-141

Parent Item Name: Automatic Lid Opener (Long Basket, Non Split Lid)

Start Date: 3/02/15

Required Date: 3/05/15

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

110 Each

53.0000

2 2

D3953-7
Spring Spacer

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST069

53

120351

4

121813

36

128889

13

DAS
66
9-89

DAS
28
9-89

D3953-9 Manufactured No

110 Each

50.0000

4 4

D3953-9
Gas Spring Washer

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST069

50

116051

19

122649

31

DAS
66
9-89

DAS
28
9-89

D3953-11 Manufactured No

110 Each

41.0000

2 2

D3953-11
Gas Spring Spacer

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST070

41

105464

31

99094

10

DAS
66
9-89

DAS
28
9-89

D3953-13 Manufactured No

110 Each

9.0000

2 2

D3953-13
Gas Spring Spacer

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST070

9

128140

9

DAS
66
9-89

APR 15 2015

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Page 3

Work Order ID: 130257

130257

Parent Item: D350-607-141

D350-607-141

Parent Item Name: Automatic Lid Opener (Long Basket, Non Split Lid)

Start Date: 3/02/15

Required Date: 3/05/15

Start Qty: 1.00

Required Qty: 1.00

D3969-1
D3969-1
 Prop
 DAS
 86
 9-89

Manufactured No

110

Each

15.0000

2 2

**

DAS
 26
 9-89

Location

Loc Qty

Loc Code

ST365

15

100609

7

127532

8

21

DAS
 28
 9-89

AN3C11A
AN3C11A
 BOLT

Purchased No

110

Each

39.0000

4

**

DAS
 26
 9-89

Location

Loc Qty

Loc Code

ST349

39

M128224

30

M130401

9

41

DAS
 28
 9-89

AN3C16A
AN3C16A
 BOLT

Purchased No

110

Each

47.0000

4

**

DAS
 26
 9-89

Location

Loc Qty

Loc Code

ST348

47

m131153

47

41

DAS
 28
 9-89

AN310-4
AN310-4
 Nut

Purchased No

110

Each

125.0000

4

**

DAS
 26
 9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

ST331

100

M129913

68

M131320

32

41

APR 15 2015

DAS
 28
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 130257

130257

Parent Item: D350-607-141

D350-607-141

Parent Item Name: Automatic Lid Opener (Long Basket, Non Split Lid)

Start Date: 3/02/15

Required Date: 3/05/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

1,414.000

8

8

MS21043-3

Nut

**

DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	124	
m130673	124	
GA	17	
m130673	17	
ST260a	400	
m131677	400	
ST304	793	
m131340	793	

DAS
28
9-89

MS24665-2-12

Purchased

No

110

Each

200.0000

4

4

MS24665-2-12

COTTER PIN

**

DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST293	200	
125044	200	

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Monday, March 02, 2015 10:45:53 AM

Page 5

Work Order ID: 130257

130257

Parent Item: D350-607-141

D350-607-141

Parent Item Name: Automatic Lid Opener (Long Basket, Non Split Lid)

Start Date: 3/02/15

Required Date: 3/05/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

4,932.000

**

8

m131697.

~~*NAS1149C0332R*~~

WASHER

DAS
66
9-89

Location

Loc Qty

Loc Code

FP001

2155

m130325

2140

m130466

15

GA

2

125654

2

ST271

2775

125654

38

m131340

737

m131618

2000

DAS
28
9-89

NAS1149C0432R

Purchased

No

110

Each

4,212.000

**

4

DAS
28
9-89

APR 15 2015

~~*NAS1149C0432R*~~

WASHER

DAS
66
9-89

Location

Loc Qty

Loc Code

GA

2476

m125807

476

m131467

2000

ST271

1736

m131452

1736

DAS
28
9-89

4x.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DAS
CS

6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1	D3953-3	GAS SPRING STUD (LID)
2	1	1	D3953-5	GAS SPRING STUD (BASE)
2	1	1	D3953-7	GAS SPRING SPACER
4	2	2	D3953-9	GAS SPRING WASHER
2	1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	1		D3953-15	GAS SPRING BRACKET
	1		D3953-17	GAS SPRING SPACER
2	1	1	D3969-1	GAS SPRING
4	2	2	AN3C11A	BOLT
4	2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	2	2	AN310-4	CASTELLATED NUT
8	4	4	MS21043-3	NUT
4	2	2	MS24665-212	COTTER PIN
8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)